






PRELIMINARY ISSUE



Acceptable to D4134 Rev. A 10-09-29

Work Order ID 62160




Monday, September 20, 2010 8:27:57 AM

Page 1

Item ID:	D4134-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Gasket					
Start Date:	9/20/2010	Start Qty:	4.00		Cust Item ID:	
Required Date:	9/27/2010	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4134	pb1								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4134 Dwg Rev: <u>pb1</u> Prog Rev: <u>pb1</u> 2-Deburr if necessary								(4)
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
									
QC	Memo	0.00							
Quality Control									

10-9-21

10-9-21

inspects b PB1

Dwg only
8/10/22

(x4)

Dart Aerospace Ltd

W/O: 62160		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.09.29	160	Acceptable to D4134 Rev. A. Width is 5.61 instead of 5.31	GP	10.09.29	4	GP 10.09.29 OS/442	

Part No: D4134-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



Work Order ID 62160


Monday, September 20, 2010 8:27:57 AM

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Item ID:	D4134-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Gasket				Stop	
Start Date:	9/20/2010	Start Qty: 4.00		Cust Item ID:		
Required Date:	9/27/2010	Req'd Qty: 4.00		Customer:		
Reference:						



Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

10.09.29 

10/09/30 

10.09.29

POSITIVE RECALL
EFFECTIVE 10.09.29 AUTH 
RELEASED  DATE 10.09.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 20, 2010 8:28:04 AM

Page 1

Work Order ID: 62160



Parent Item: D4134-3



Parent Item Name: Gasket

Start Date: 9/20/2010

Required Date: 9/27/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.25 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	477.6133	1.0435	4.393684			



NEOPRENE SHEET 0.063



B10-9-21

Location

Loc Qty

Loc Code

MAT

372.3602

114691

105.9602

115500

266.4

MAT052

105.2531

114176

105.2531

115500

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		Hole at 2.7" location should be at 5.85" location	<i>JB</i> 09/09/29	Add hole at 5.85" location. Eng to change	JB 10/09/29 EB 10/09/29	<i>JB</i> 10.09.29	<i>JB</i> 09/09/29	<i>JB</i> 10.09.29

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 62160
Description: GASKET		Part Number: D4134-3
Inspection Dwg: D4134-3 Rev: pbl		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

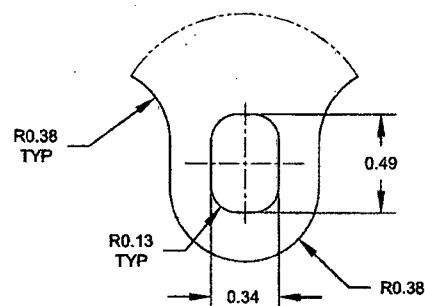
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 31	+ .006 - .001	.315	*		V 1B02	
34	± .030	.338	*		V	
49	± .030	.495	*		V	
49	± .030	.490	*		V	
97	± .030	.913	*		V	
2.81	± .030	2.749	*		V	
4.64	± .030	4.635	*		V	
5.12	± .030	5.108	*		V	
5.61	± .030	5.616	*		V	
.38	± .030	.378	*		V	
2.70	± .030	2.690	*		V	
8.25	± .030	8.247	*		V PRO 0218	
11.23	± .030	11.242	*		V "	
13.17	± .030	13.17	*		T 1B01	
15.85	± .030	15.85	*		T	
18.09	± .030	18.09	*		T	
20.48	± .030	20.49	*		T	
23.01	± .030	22.981	*		T	
25.85	± .030	25.85	*		T	
27.93	± .030	27.93	*		T	
28.31	± .030	28.31	*		T	
.063	± .010	.059	*		V	

Measured by: PB	Audited by: S	Prototype Approval:	N/A
Date: 10-9-21	Date: 10/9/22	Date:	N/A

inspector to PBI Day only

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

D4134-3 GASKET



DETAIL D
CT-6
SCALE 5X

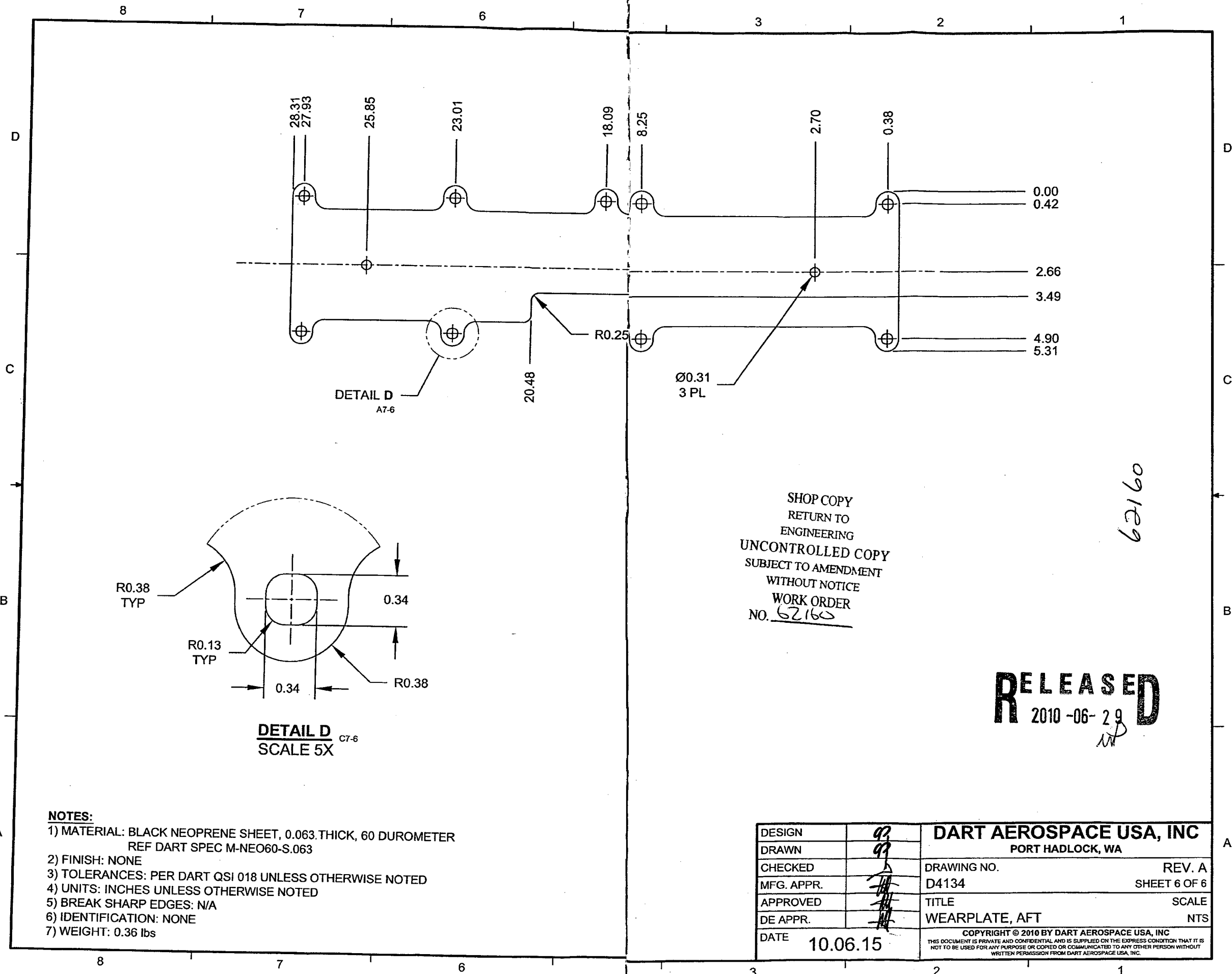
NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
REF DART SPEC M-NEO60-S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.36 lbs

DESIGN	<i>q2</i>	DART AEROSPACE USA, INC	
DRAWN	<i>q2</i>	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. <i>B</i>
MFG. APPR.		D4134	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE, AFT	NTS
DATE	10.09.15	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

PRELIMINARY ISSUE

q10.15.15



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62160

RELEASED
2010-06-29
MP

- NOTES:**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
REF DART SPEC M-NEO60-S.063
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.36 lbs

DESIGN	92	DART AEROSPACE USA, INC	
DRAWN	92	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4134	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE, AFT	NTS
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